

Date: Thursday, 06/12/2007 10:25:19 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D135-751-011 REWORK  
 Job Number : 36164  
 Estimate Number : 10804  
 P.O. Number : N/A Part Number : D135751011  
 This Issue : 06/12/2007 S.O. No. : N/A Drawing Number : ECN1036  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A  
 Previous Run : 00015 Material : N/A  
 Written By : Due Date : 13/12/2007 Qty: 1 Um: Each  
 Checked & Approved By :  
 Comment :

## Additional Product

Job Number:



<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
PN	D135-751-011	CHG	CHG001
DFSC	Skidtube	SIC	SR01709SE
LOT	B28957	SIC	
MODIF	EC135 P1/P2/T1/T2	SIC	
US PATENT # 6,735,484		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

Seq. #: Machine Or Operation:

1.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D135-751-011 B28957 9 26456

2.0 D135751011

SKIDTUBE INSTALLATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 SKIDTUBE INSTALLATION

3.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE 1 X D3508-7 REV.B WEARPLATE  
 REMOVE 2 X D3512-1 REV.B WEARPLATE  
 SCRAP BOTH  
 REWORK SKID PER DRWG IAW D3507 REV.C  
 (DRILLING DETAIL HAS CHANGED)

ADP  
 7-12-6

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ALUMINUM ROD BM 105138

WELD 2 X D3504-5 CROSSBOLT SPACERS  
PER DRWG D3507 REV.C

BE 07-12-13

6.0

D35045

CROSSBOLT SPACER



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)  
CROSSBOLT SPACER

B 36181

BE 07-12-13

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QCC 5/12/14

Qc9 07/12/14

8.0

POWDER COATING

POWDER COATING

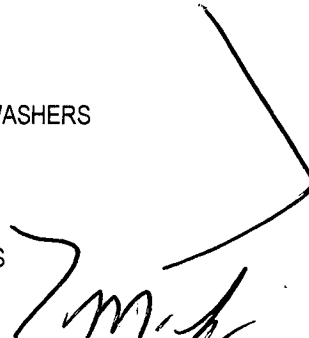


Comment: POWDER COATING

REMOVE ALL EXISTING PARTS:  
WEARPLATES, CAPS, INSERTS, BOLTS, WASHERS  
KEEP EXISTING WEARPLATES & CAPS  
DISCARD INSERTS, BOLTS & WASHERS

N/A  
RH  
07/12/17

MASK D3506-1/-3 DOUBLER, PLUG HOLES  
RE-POWDER COAT PER QSI005  
(STRIP IF NECESSARY)



BE 07-12-17

07/12/17 (1X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 07/12/17 (1)

10.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)  
Insert

NOT  
REQ'D  
07.12.17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36164

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

ALS41032225

Insert



NOT  
REQ'D



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Insert

PH  
07.12.17

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RE-ASSEMBLE CAPS (SIKAFLEX) B  
& WEARPLATES  
PER DRWG D3507 REV.C

m 105585

4x D3492041  
B 35588

PICK NEW 1 X D3508-7 REV.C B  
INSTALL PER DRWG D3507 REV.C

B 36179

2x D3492047

PICK 4 X D3492-043 PLUGS B  
INSTALL PER DRWG D3507 REV.C

B 35840

B 27776

FL 07/12/17 ①

Wingwalk

B 106332

m-1 07/12/17 ②

13.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
PLUG ASSEMBLY

B 35840

FL

14.0

D35087

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARPLATE

B 36179

FL

15.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)  
BOLT

m 106431

FL

16.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)  
washer

m 106302

FL 07/12/17 ①

1x D3558-7

B 30001

FL

1x D3558-1

B 29998

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Bolt *m106552*

*FZ*

18.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Screw *m15072*

*Fd.*

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 7/12/18 (X)*

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
ENSURE ORIGINAL KIT IS INCLUDED  
ADD:

2 X D3512-1 \*\*REV.C\*\* WEARPLATE B

*381127*  
~~*361180*~~

21.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
WEARPLATE *B311180*

*NO Gant*

*B36180 new*

*AS 7/12/19*

*(X)*

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*5 7/12/19 (X)*

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP  
USING NEW B/N - CHG 001

*PRAT 6/12/21*

*36164*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 12 Date: 01/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.12.07  
POSITIVE RECALL

EFFECTIVE 07.12.07 AUTH CA

RELEASED 07.12.07 DATE 6

Don 12/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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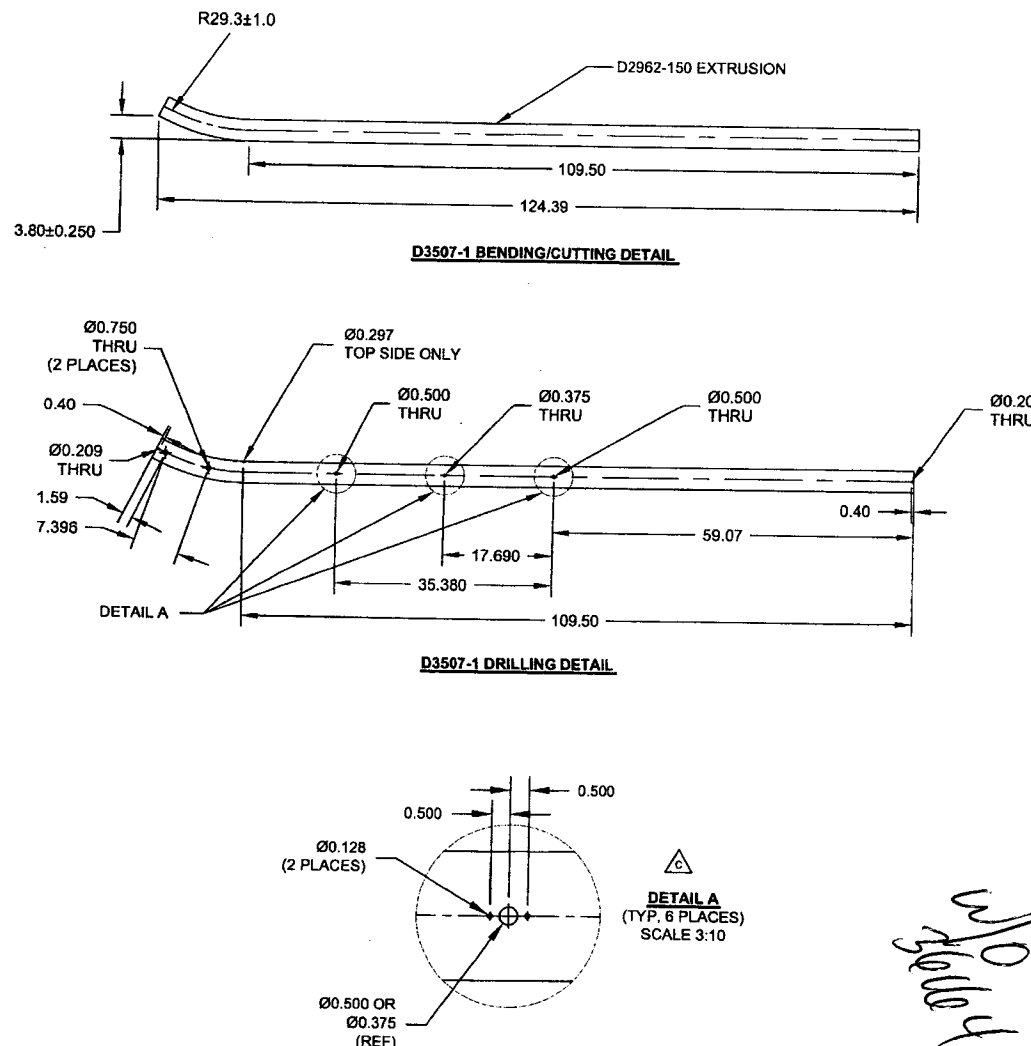
NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

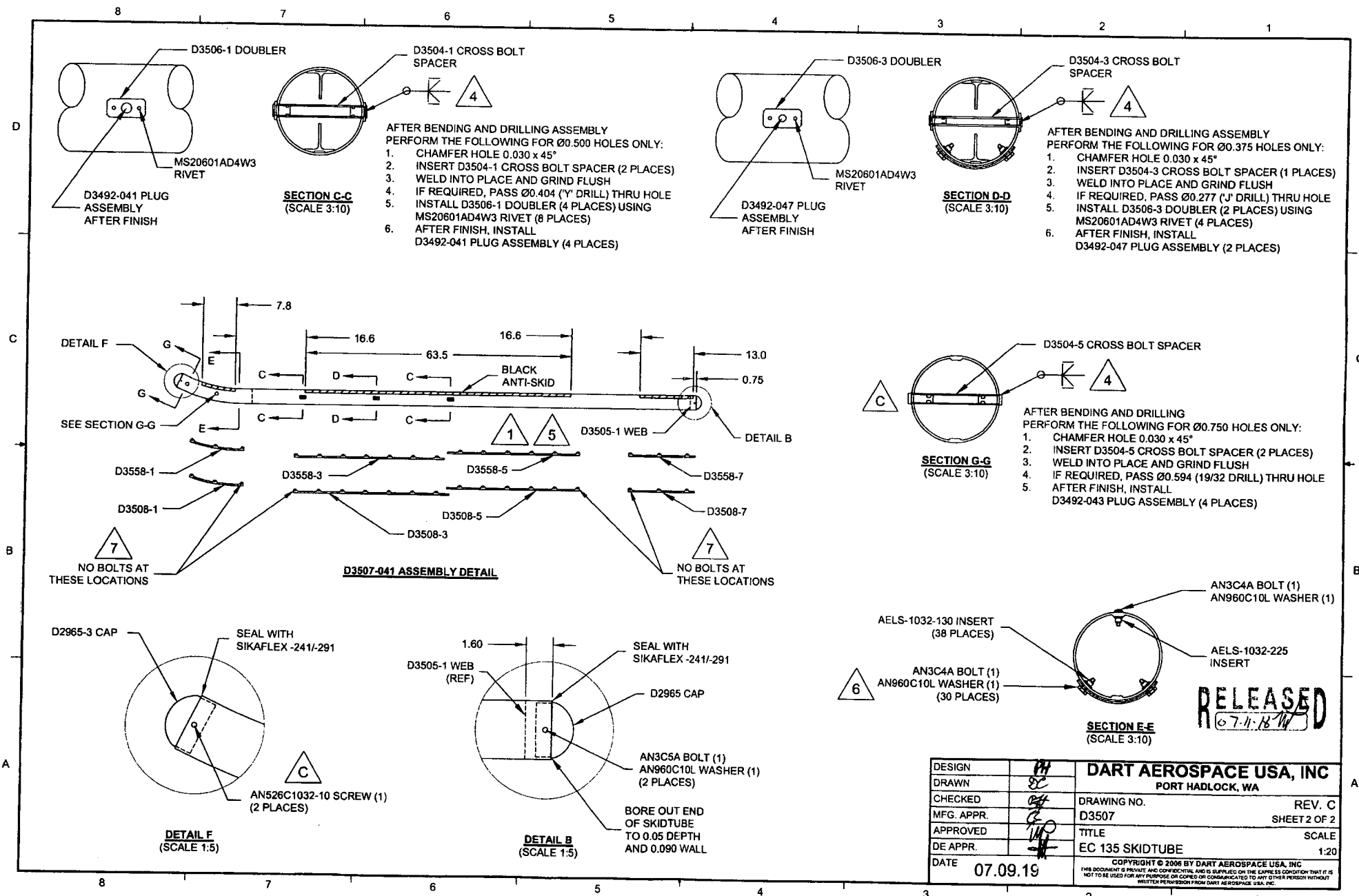
# GENERAL NOTES:

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	GP		
APPROVED	JP		
DE APPR.	JP	DRAWING NO. D3507 REV. C SHEET 1 OF 2 TITLE SCALE EC 135 SKIDTUBE NTS	
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



RELEASED  
07.11.16



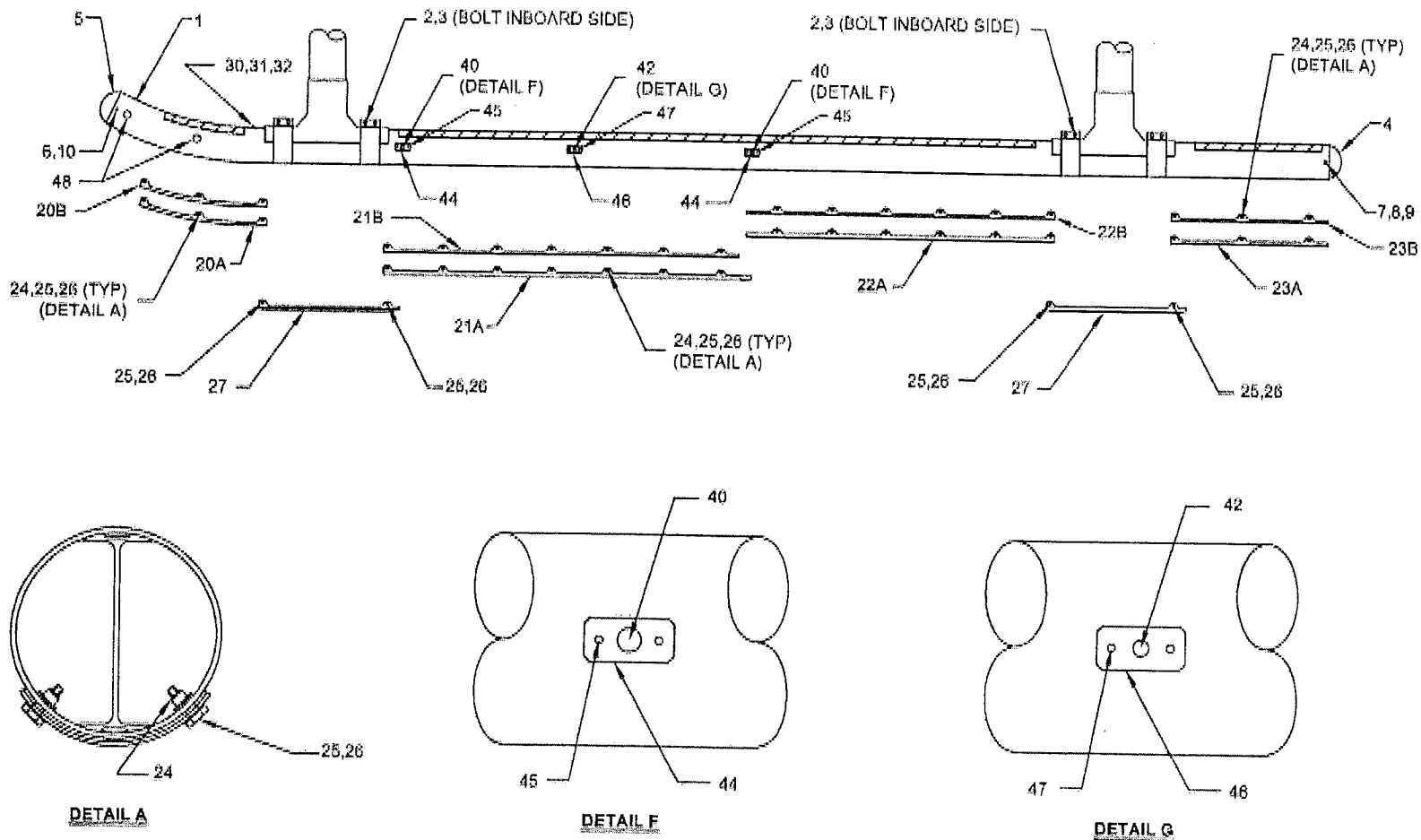


FIGURE 2 – D135-751-011 SKIDTUBE INSTALLATION

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Revision: C

Date: 07.09.20

